User:

Friday, 17/04/2009 10:06:10 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 47264

Estimate Number

: 10604

P.O. Number

This Issue

: 17/04/2009

Prsht Rev.

: NC

First Issue Previous Run

Written By

: // : 46086

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Due Date

Drawing Name

: D2581

: D2581 REV A1

: MOUNTING BRACKET

Drawing Number

: N/A : A1

Project Number **Drawing Revision**

Material

: 23/04/2009

Qtv:

32 Um:

Each

Checked & Approved By

Comment

: Est. D 01.07.17

Added info to step 2

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S11GA

304/316 0.125 Sheet



Comment: Qty.:

0.0196 sf(s)/Unit

Total:

0.6283 sf(s)

304/316 .125 Sheet (M304S0125)

Batch: 111 333

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2581 Dwg Rev: A1

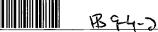
Prog Rev: A

B9470

2-Deburr if necessary

3.0

QC2



B9-4-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

4.0

QC8

Comment: SECOND CHECK

BRAKE NC



5.0

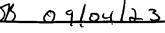
NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2581 using CNC Brake





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								1 100 1119				
<u>-</u>												
Part No	•	PAR #:	Fault Category: NCR: Yes No DQA: [
		esolution:					Date:					
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NO	R)						
DATE	CTED	Description of NC	Description of NC Corrective Action		ction B	Veri	Verification Approval		Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	l&t∣ _{Se}	ction C	Chief Eng	QC inspector			
					·							

Date: Friday, 17/04/2009 10:06:10 AM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: MOUNTING BRACKET** Job Number: 47264 Part Number: D2581 Job Number: Seq. #: Machine Or Operation: Description: 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock

Location: Basket

QC21 8.0

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4 59.05.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-				

Part No: _		PAR #:	AR #: Fault Category:		DQA: Dat	te:
	Resolution:		Disposition:	QA: N/C Close	d: Dat	te:
NCD.		WC	ORK ORDER NON-C	CONFORMANCE (NCR)		,

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	0	Description of NC		Corrective Action Section B	}	Verification	Approval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
						· · · · · · · · · · · · · · · · · · ·					

DART AEROSPACE LTD	Work Order:	47264
Description: Mounting Bracket	Part Number:	D2581
Inspection Dwg: D2581 Rev: A1		Page 1 of 1

	FIRST	ARTICLE IN	ISPECTIO	ON CHE	CKLIST		
	X	First Artic	ele	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.328	+0.006/-0.001	329	*				
Ø0.191	+0.005/-0.001	.193	8 €				÷
0.750	+/-0.010	757	X				
3.596	+/-0.010	3,596	V				
2.846	+/-0.010	2.846	y				
1.995	+/-0.010	1,996	*				
R0.250	+/-0.010	.350	*				
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Measured by:	包	Audited by:	5		Prototype Appro	val:	N/A

Measured by:	包	Audited by:		Prototype Approval:	N/A
Date:	9-4-70	Date: O	ilalio	Date:	N/A
		<u> </u>			

Rev	Date	Change	Revised by	Approy ∉ d
A	07.01.23	New Issue	KJ/JLM O	\J\]

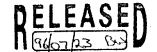
Dart Ae	rospace Ltd										
W/O:			WORK ORDER	CHANGES							
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								:			
								;			
Part No	:PAR #:		Fault Category:	NCR: Ye	A:	Date: _					
	Resolution:	ion: Disposition:		QA: N/C		Date:					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)								

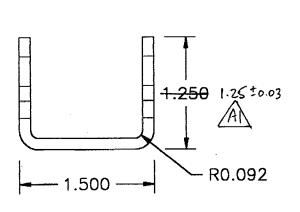
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.4.T.E		Description of NC		Corrective Action Section B	***************************************	Verification	Ammanual	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
							_				

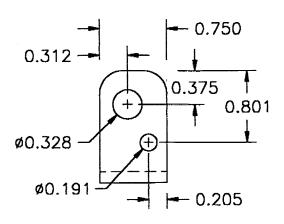


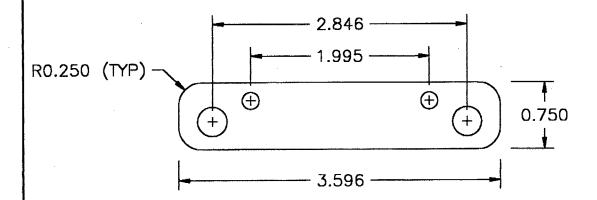


	DESIGN MIKE M	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA					
	CHECKED	APPROVED	DRAWING NO.	REV. A				
)	Bu	MM	D2581	SHEET 1 OF 1				
/	DATE		TITLE	SCALE				
	96.06.27		MOUNTING BRACKET	1:1				
	Al # if	04.05.14	CHANGE TOWERANCE ON 125	DIMOVSION				









MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	ES						
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
		esolution:						Date: _			
NCR:		·	WORK ORD	ER NON-CONFORMA	ANCE (NO	R)					
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description				- Verification Section C	Approval	Approval		
		Section A	Chief Eng	Chief Eng	Da		ion C	Chief Eng	QC Inspector		
